

Date: Thursday, 29/05/2008 11:04:59 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CAP
 Job Number : 39562
 Estimate Number : 10519
 P.O. Number :
 This Issue : 29/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : PURCHASED PARTS
 Previous Run : 38395
 Written By :
 Checked & Approved By : JUL 08.5.29
 Comment : Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC

Part Number : D2855
 Drawing Number : D2855 REV. A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 10/06/2008 Qty: 30 Um: Each

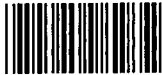
Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 6469

Cast per Dwg D2855

Material Release Note Required

C208/05/30

(30)

2.0 D2855P Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
 CAP

C208/05/30

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4
 C208/06/19 (30) counts

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

C208/06/19 (30) counts

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

C208/06/23 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/06/23 (x30) counter

7.0

POWDER COATING

POWDER COATING



~~MA 102316~~



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

~~8:35~~ 8:50

OVEN TEMPERATURE:

~~320°~~ 320°F

FINISH TIME:

~~8:25~~ 9:20 AM

9/1 08-06-24 (x30)

~~FL 08/06/24~~

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/06/24 (30)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

m/100489.

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

FL

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

FL 08/06/24

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/06/24 (x30) counter

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-22

FL 08/06/24 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CAP

Job Number: 39562

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/25 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



- 08/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

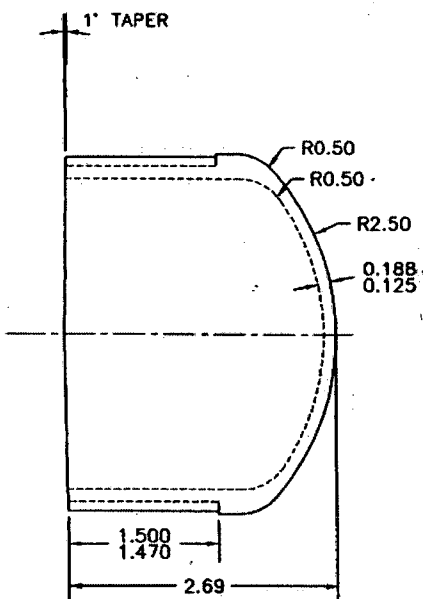
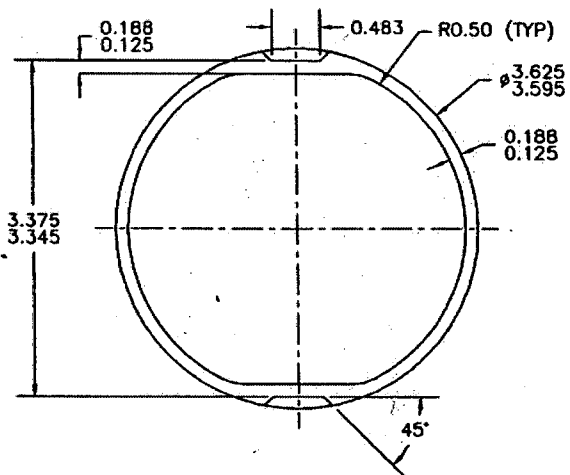
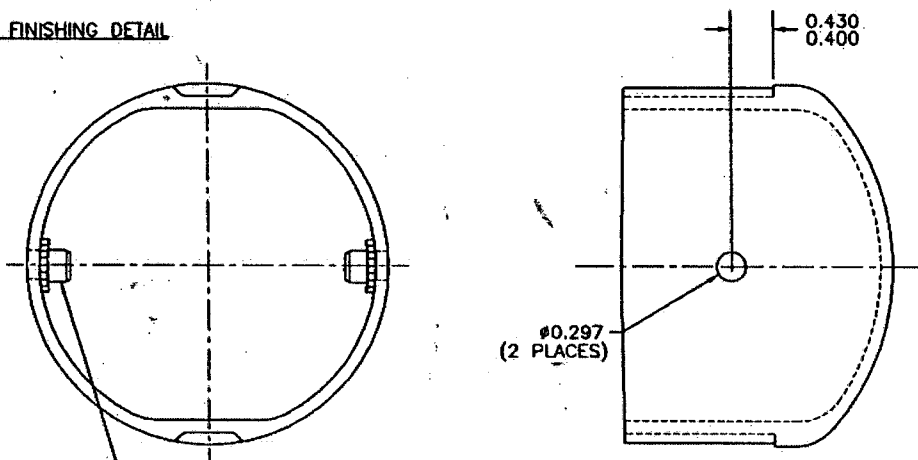
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	<i>WJ</i>	DRAWN BY	<i>WJ</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>CP</i>	APPROVED	<i>WJ</i>	DRAWING NO. D2855
DATE	98.12.12	TITLE	CAP	REV. A SHEET 1 OF 1
A	96.12.12	SCALE	NIS	NEW ISSUE (WAS D2575 REV. E)

RELEASED
98.12.14 DS**D2855 CASTING DETAIL****D2855 FINISHING DETAIL**

INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39562

Aluminum Foundry Ltd

714-716 Calais

Dorval, Québec H9P 2P3

Tel: (514) 631-1331

Fax: (514) 631-8448

Packing Slip

Packing Slip No.:

32616

Date:

Jun 17, 2008

Page:

1

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 000006489 ⁶ 00006469	Sold By:
Shipped By:	Ship Date: Jun 17, 2008
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	30
Comment:			

**7 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE**

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Date: **17/06/2008** Packing Slip No. **32616**

Hawksbury, ON, K6A 1K7

Votre No. Commande **00006489**
Your order No. **00006469**

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
4030	D 2855 CAP	Z098046	A356.2	ingot#851118

**Analyse
Analysis (as in ingot)**

(Si)	7.00%	(Al)	balance
(Fe)	0.06%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne
Yield :

Résistance à la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dép :
Par/Per :

Coc-100